

Date: Friday, 05/09/2008 7:34:44 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FUEL PURGE CANISTER
 Job Number : 41823
 Estimate Number : 10440
 P.O. Number : Part Number : D3262041
 This Issue : 05/09/2008 S.O. No. : Drawing Number : D3262 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : 04/09/2008 Type : LARGE FAB ASSY Drawing Revision : C
 Previous Run : 41167 Material :
 Due Date : 30/09/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est. C 05.03.10 Removed P/O for liquid penetrant inspection K
 J/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D32621 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Tube *3 41167 A (42)* *BE 08/09/18*

2.0 41823B FUEL PURGE CANISTER



Comment: Sub-Component FUEL PURGE CANISTER
 2 x D3262-3 Batch *3 41823 (8PC)* *BE 08/09/18*

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
 Weld canister assembly as per Dwg D3262 using DT8739 to align fillings
 Pick: Qty Part Number Description Batch
 A/R Aluminum Rod *17/08 708 BE 08/09/18*

4.0 QC9 VISUAL WELDING INSPECTION



Comment: WELD INSPECTION
 Pressure test as per Dwg D3262

PD 08.09.18 (4)

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2 08/09/18 (4)

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Drawing Name: FUEL PURGE CANISTER

Job Number: 41823

Part Number: D3262041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(4X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L

08/09/14

7.0

POWDER COATING

POWDER COATING



M 108523



(4X)

Comment: POWDER COATING

1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

2-Ensure to mask threads

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:45
01
320
8:15

M-L

08/04/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SS 08/09/22 (X4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: ST 164

SS 08/09/22 (X4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/23

Job Completion



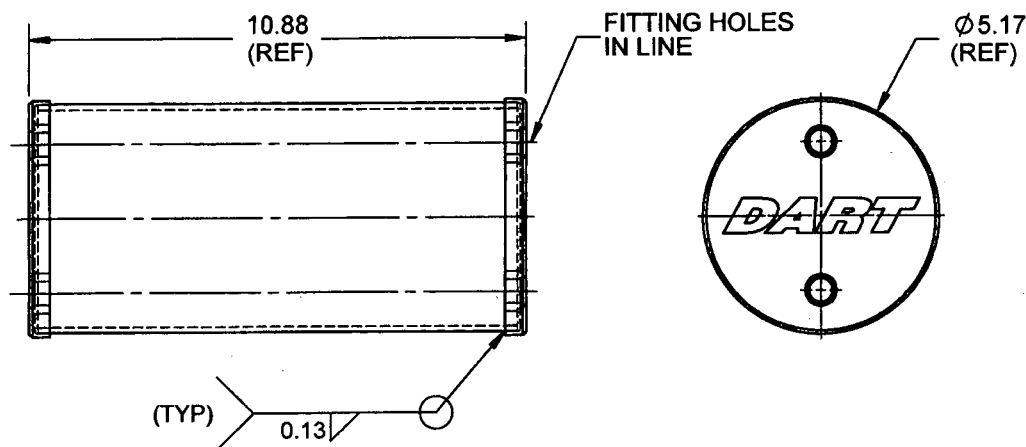
mf 08-09-22



DESIGN <i>PH</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>B</i>	DRAWING NO. D3262	REV. C SHEET 1 OF 2
DATE 06.08.31		TITLE FUEL PURGE CANISTER SCALE 1:4	
REV	DATE	DESCRIPTION	
A	04.05.06	FIRST ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	
C	06.08.31	Ø5.165 WAS Ø5.190	

RELEASED

06.09.19 *PH*

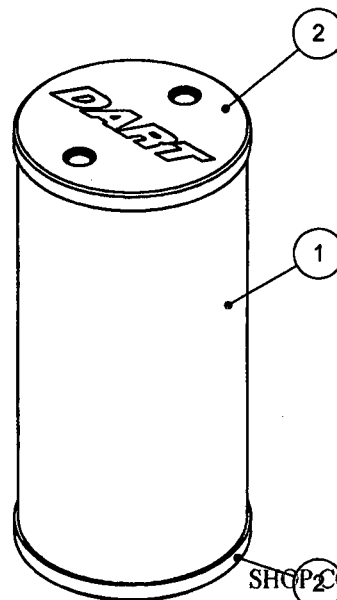


D3262-041 CANISTER ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



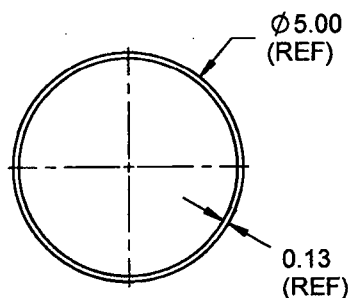
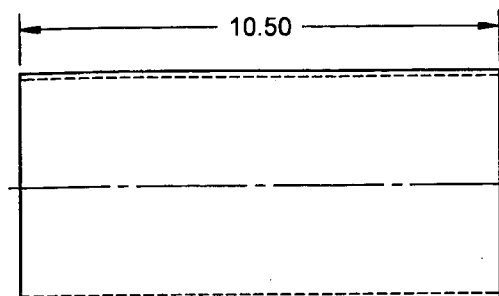
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NO. *41823*

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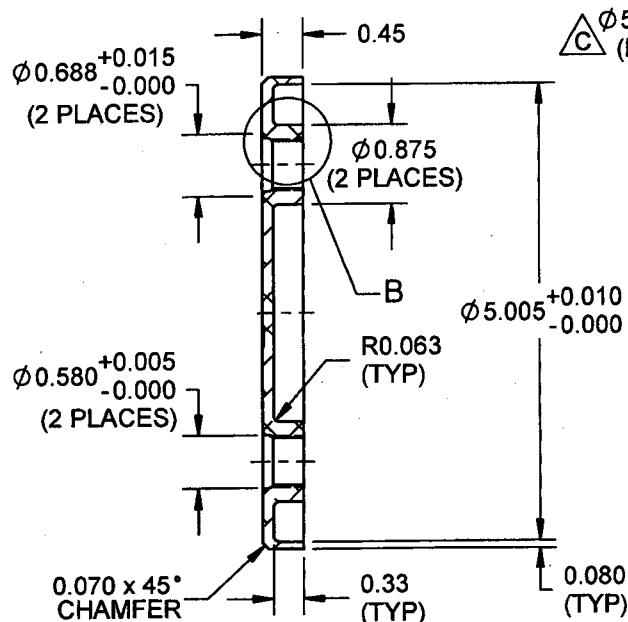
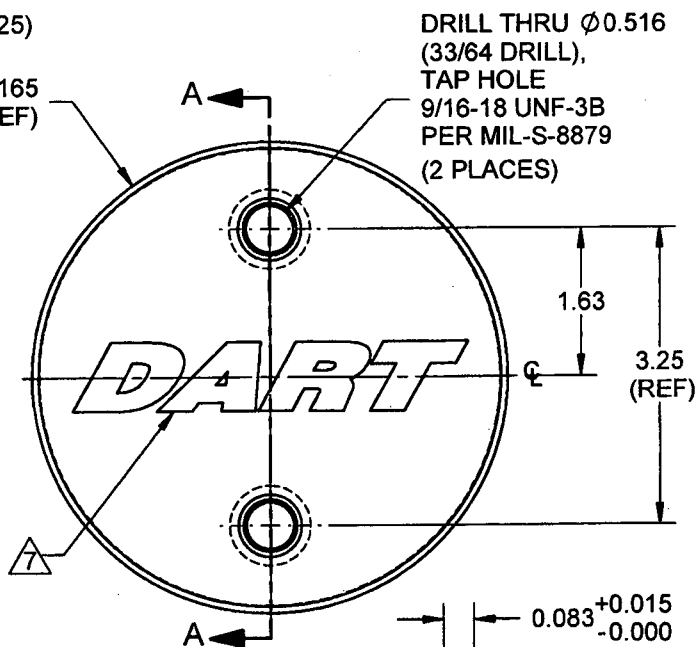
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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	REV. C SHEET 2 OF 2
DATE 06.08.31	TITLE FUEL PURGE CANISTER		SCALE 1:4

**RELEASED***06.09.19***D3262-1 TUBE**

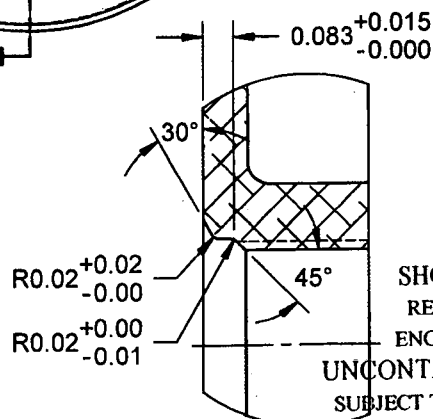
- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)

**SECTION A-A**
SCALE 1:2**D3262-3 CAP**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)

**DETAIL B**
SCALE 2:1

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